Thursday, 28/05/2009 11:33:55 AM

Julie Dawson User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 48271 **Estimate Number** : 11010

P.O. Number

This Issue

: 28/05/2009

S.O. No. : : NC

: //

Previous Run

: 47112

Type : MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D2649

: CROSSBOLT SPACER

: D2649 REV B1

Project Number

: N/A : B1

Drawing Revision

Material

Due Date : 04/06/2009 Qty:

200 Um:

Each

Checked & Approved By

Comment

Written By

Prsht Rev. First Issue

NG 02.03.26 Added turning on Cobra

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6T0375W058

Description:

6061-T6 RD Tube .375 x.058W

Comment: Qty.:

0.2975 f(s)/Unit

Total: 59.4930 f(s)

6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA214 on cobra machine.

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



31

4.0

QC8

SECOND CHECK





5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



6.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Page 1

Form: rprocess

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					Ē					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification						
DATE	STEP	Section A		InitialAction DescriptionSignChief EngChief EngDate		Section C	Approval Chief Eng	Approval QC Inspector			
								:			
								,			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	14827
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649 Rev: B1		Page 1 of 1

	FIRS	ARTICLE II	NSPEC II	ON CHE	CKLIST		
	x	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
3.180	+0.030/-0.000	3,195					
0.375	+/-0.010	.375					
0.025 - 0.030	N/A	,025					
	1.00						
			,				
						-	
							
				I	1		
Measured by:	P	Audited by:			Prototype	Approval:	N/A
Date:	09.05.31	Date:	09/04/0			Date:	N/A
Rev Date	Change		11			Revised by	Approved
Δ 04.01.21	New Issue				-	Revised by	Approved

Dart Aerospace Ltd

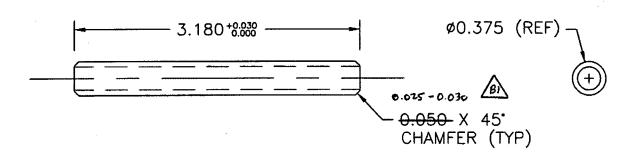
										
W/O:			WC	ORK ORDER CHAN	GES					
DATE	STEP	· PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					•					
Part No		DAD #-	Fault Cata	gory.	NCD.	Voc. N	do DO	Λ.	Deter	
Part No: PAR #:			Disposition: QA			-				
NOD		,		ER NON-CONFORM						
NCR:						iven)				
DATE	STEP	Description of NC Section A	Initial Action Description			Verifica			Approval	Approval
	-	Section A	Chief Eng	Chief Eng		Date	Section C		Chief Eng	QC Inspector
·							†			

NOTE: Date & initial all entries



	DESIG	Sas	DRAWN BY	DART AEROSPACE USA, INC.
ı	CHECH	(ED)	APPROVED	DRAWING NO. REV. B
	I	<i>YUY</i>	BW	D2649 SHEET 1 OF 1
	DATE		•	TITLE SCALE
	98.0	01.14		CROSS BOLT SPACER 1:1
	Α		97.03.25	NEW ISSUE
	В		98.01.14	3.180 WAS 3.230, ADD CHAMFER
	Ві	# (8	02.06.13	REDUCE CHAMPER PER TSR 1246.

RELEASED



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL SHOP COPY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED OF ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Dart	Aer	os	oace	Ltd
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W/O:			WC	RK ORDER CHANG	ES					
DATE STEP		PRO	OCEDURE CHA	NGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										:
-										
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes I	No DQA	٨:	_ Date: _	
Resolution:			Disposition: Q			_ QA: N/C Closed: Date: _				
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)				
DATE	CTED	Description of NC	Corrective Action Section B			VArii			Approval	l Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC inspector
		1								
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NOTE: Date & initial all entries